

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026825**Date Inspected:** 06-Dec-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA

CWI Name:	Chris Concha		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** Maintenance Travelers**Summary of Items Observed:**

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Westmont Industries (WMI) jobsite in Santa Fe Springs, California for the purpose of observing fabrication and QC functions for the SAS Superstructure, Bid Item #99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike Path).

Traveler Trolley Train Suspension System Assembly (Revised Brake Mount Mock-up testing)

This QA Inspector randomly observed WMI production personnel Mr. Richard Fuentes and helpers assembling trolley train suspension system with revised brake mounts mock-up for testing on the 10 meter curved radius. QA noted that Caltrans Structures Representative - Mr. Robert Kobal, ABF - Mr. Chris Bausone, WMI – Mrs. Ida Goldenberg, Mr. Ray Meier, John Otter Engineering - Mr. John Otter and Hydraulic Controls - Mr. R. Scott on site at Westmont Industries to observe revised brake mount mock-up testing today. After testing was completed this QA attended meeting with Caltrans Structures Representative Mr. Robert Kobal, ABF - Mr. Chris Bausone, WMI – Mrs. Ida Goldenberg, Mr. Ray Meier, Mr. Curt Bell, Mr. Manny Macias John Otter Engineering - Mr. John Otter and Hydraulic Controls - Mr. R. Scott with discussions on Revised Brake Mount for the Traveler Trolley Trains, Balcony Modifications, and pneumatics for console boxes which will supplied by Zemarc. This QA informed Caltrans SMR Mr. Nicolai Hvass of the above mock up testing and meeting discussions.

Miscellaneous Traveler Modifications

This QA Inspector randomly observed WMI qualified welder Mr. Larry Swanson WID #3058, performing layout, fitting and tack welding on two (2) platform balconies for the SAS Traveler balcony modifications. Note: The two balconies for the SAS Travelers had been completed previously. See CCO 183 – Miscellaneous Traveler Modifications for additional information. WMI is aware that they are proceeding at their own risk pending

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drawing approval.

SAS WB Traveler

This QA Inspector randomly observed Smith Emery, CWI, QC Inspector Mr. Chris Concha performing visual inspection on the SAS WB traveler. Mr. Concha informed this QA Inspector that he had found several areas for in process grinding and welding. This QA Inspector randomly observed WMI production welder Mr. Eutimo Lopez (WID # 3035) grinding and welding areas found Mr. Concha using Flux Core Arc Welding (FCAW) process in all positions on tube steel and plate material, randomly throughout the shift. QC visual inspection and pick-up welding not completed on this date.

RPI Coating (Blast and Paint)

This QA Inspector performed random shop observations and observed that RPI is on site to continuing with the coating application. QA Inspector was informed by RPI Coating Mr. Preston Keen that RPI is going to apply mist coat on (3) elevating platforms, (3) balconies and mist and top coat bike path assemblies using the Sherwin Williams Polysiloxane XLE-80, today. Environmental readings taken by RPI at the time of coating application are as follows: Environmental readings taken by RPI at the time of the coating application are as follows Air Temperature 44/47 F, Relative Humidity 48/41%, Wet Bulb Temperature 37/39 F, Dew point 26/25 F and Surface Temperature 41/42 F.



Summary of Conversations:

As stated within this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910 , who represents the Office of Structural Materials for your project.

Inspected By: Brannon, Sherri

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer